

Work Order ID 127364

December-17-14 1:15:17 PM

127364

Page 1

Item ID: D3239-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cover
 Start Date: 12/17/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3239	Rev A

100	FLOW WATER JET	0.00							DAS 23 9-89 15-1-5
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100
 Waterjet
 FLOW CNC Waterjet
 6061-050
 Memo
 1-Cut as per Dwg D3239
 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89 15-1-5
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110
 QC
 Quality Control
 Memo

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Crosstube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Reference:

Run	Start	*NR1*
	Stop	*NR2*

120

120

OC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

0.00

0.00

0.00

0.00

DAS
9
9-89

130

130

Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary.

140

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

DQA: _____ Date: _____



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Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
150						(14)			
QC	Memo	0.00							
Quality Control									JAN 05 2015
160	Identify as per dwg & Stock Location: <u>St 031</u>	0.00							
160									
Packaging	Memo	0.00							JAN 06 2015 14 DAS 86 9-89
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									15/1/16 JH

Handwritten signature and date: 15-1-06

DQA: _____ Date: _____



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Picklist Print

December-17-14 1:15:17 PM

Page 1

Work Order ID: 127364

127364

Parent Item: D3239-1

D3239-1

Parent Item Name: Cover

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev: A New Issue 05-11-06 JLM
IPP: b 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.050

Purchased

No

100

sf

47.5000

0.18

151579

DAS

M6061T6S 050

**

(2)

23
9-89

15-1-5

6061-T6 .050 Sheet

Location

Loc Qty

Loc Code

MAT021

47.5

125636

15.5

M128408

32

125636

DQA: _____ Date: _____



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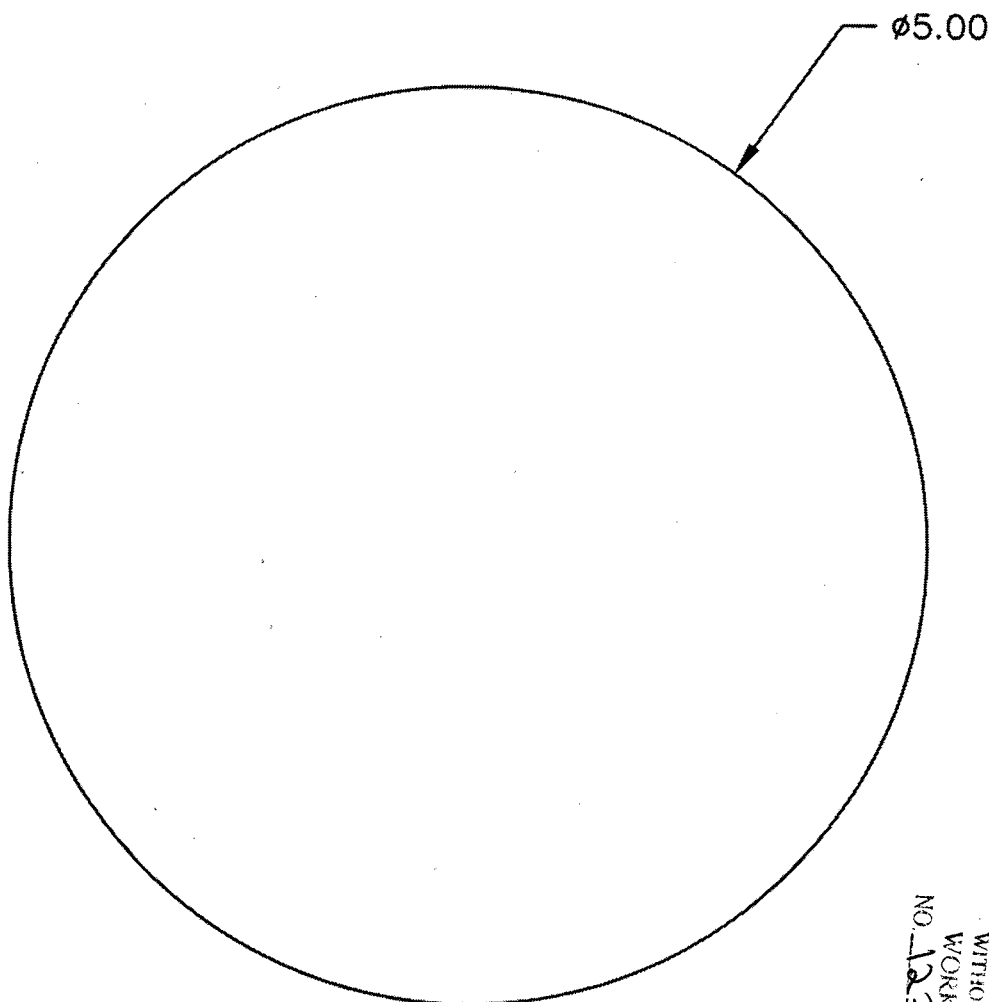
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3239	REV. A SHEET 1 OF 1
DATE 03.12.19		TITLE COVER	SCALE 1:1
A	03.12.19	NEW ISSUE	

RELEASED
04.02.03



NO. 122364 MJS
14-12-19
WITHOUT LEAVING
WORK AREA
UNCONTROLLED
ENGINEERING
RETURN TO
SHOP COPY

D3239-1 COVER

- 1) MATERIAL: 6061-T6 (QQ-A-250/11), 0.050 THICK (REF. M6061T6S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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